

THE CHEMICAL CO. INC.

BOMATIA

BULLITT UNION

TURCO PRODUCTS • A DIVISION OF PUREX CORPORATION, LTD. • WILMINGTON, CALIFORNIA 90744 • OFFICES IN ALL PRINCIPAL CITIES

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TURCO 5580-G

DESCRIPTION

Hand strippable coating formulated for one coat application with hot airless spray equipment to provide protection to metal surfaces during successive fabrication operations such as chemical cleaning, conversion coating, adhesive bonding, machining and forming.

This material meets Air Pollution Control Districts' Rule 66 in Los Angeles County and Regulation 3 in the Bay Area.

Appearance: Green liquid that dries to a tough chemical-resistant elastomeric film.

Impact Resistance: Excellent.

Abrasion Resistance: Excellent.

Chemical Resistance: Resists emulsion cleaners, anodize solutions, alkaline cleaners, acid deoxidizers. Will degrade upon exposure to most hydrocarbon solvents and oils.

LIQUID PROPERTIES

Solids content by wt....17.6%±2%
Solids content by vol....18.7%±2%
Gallon weight.....12.0 pounds
Flash point, TOC.....above 175°F
Freezing point..... -22°F
Storage life at 70°F....min 1 yr.
Color..... Green

FILM PROPERTIES

Tensile strength, min.....1200 psi
Elongation at rupture.....500% min.
Peel adhesion, pounds per inch width, clad aluminum.....0.8±0.2
(Film properties for 4 to 6 mils films air dried for 24 hours)
Coverage at 1 mil dry film..300 sq.ft
ga

HAZARDOUS PROPERTIES

Read precautionary information carefully before opening. Open container carefully to avoid spurting. CAUTION: Prolonged exposure to high concentrations of vapor may cause irritation to eyes and respiratory tract. Contains chlorinated hydrocarbons.

Avoid contact with skin and eyes. Avoid prolonged or repeated breathing of vapor. Do not take internally. Use with adequate ventilation.

PROCESS APPLICATION

Protects against scratches during shop handling.

Provides chemical resistance against:
Type I Anodize (chromic acid)
Aqueous cleaning solutions.
(Material will dissolve on exposure to solvents or vapor degreaser.)

Recommended for use on:
Bare and Clad Aluminum
Magnesium
Steel

Prevents physical damage during:
Stretch forming.
Bonding at 250 or 250°F., and releases Mylar.

DIRECTIONS FOR USE

The directions and recommendations given are intended to serve as a general guide to processors and may require modification, based on field experience, to meet local conditions.

Storage: Freezing point is -22°F. Material may revert to a soft gel on standing. This will in no way impair the performance of the product. Warm to room temperature prior to mixing.

Mixing: To assure uniform and reproducible results, adequate mixing of the solution is necessary prior to use (once per eight hour shift).

Surface Preparation: Apply to clean, dry surfaces.

Application: Apply by hot airless spray according to instructions attached.

Drying: Avoid excessive heat and drafts on wet film, as these can cause undesirable skin-drying. Heat or ventilation applied to force the drying should be utilized only if the user observes that film quality is satisfactory under these conditions.

Cure Schedule: Air cure schedule: After the final coat is tack-free, allow the film to dry at ambient temperature above 60°F for four (4) hours minimum before processing. Oven cure schedule: Tack-free film may be oven-cured for 30 minutes at 175-225°F to speed the cure.

Dry Film Thickness: 5 - 8 mils is recommended.

Coating Removal: Film is generally hand-strippable after processing. Stripping may be facilitated by total immersion in Turco special solvent blends. Consult with service representative for recommended materials.

Packaging: 55 gallon F.O.T. drums; 5 gallon steel pails.

HOT AIRLESS SPRAY APPLICATION

Mix thoroughly before use.

Apply as received. This material is packaged in ready-to-spray. If performance indicates it is necessary to add thinner, use Turco 5580-66 Thinner. Zahn Cup viscosity readings are misleading and not recommended to control application viscosity.

Equipment:

- (a) Graco President (28:1) or Bulldog (30:1) hot airless spray unit or equivalent.
- (b) Graco Reflex gun; Reverse-A-Clean nozzle, to facilitate cleaning clogged tips, or, Spee-Flo gun, Model 801-081; swivel strainer assembly 912-022 with 100 mesh screen.
- (c) Graco tip 163-919 or 163-621. For small parts, 163-515. Spee-Flo tip 702-218 or -188. For small parts, 702-155.
- (d) Two 4 KW Spee-Flo heaters in series; or Graco heaters adapted with 680-688 insert rods; or any heaters capable of maintaining fluid temperature at 180-200°F.

Pressures and Temperature:

- (a) Temperature 180 to 220°F
- (b) Fluid Pressure 2200 to 2500 psi
- (c) Back Pressure 1900 to 2100 psi
- (d) Line Pressure 80 to 110 psi

Apply as follows:

- (a) Hold the gun approximately 12 to 15 inches from the part.
- (b) Spray $\frac{1}{2}$ box coat; that is, one horizontal pass; overlap 75 to 80%. Spray one box coat; that is, one vertical pass and one horizontal pass; overlap 50%.
- (c) Dry film build will be about 5 to 10 mils depending on the speed at which the spray gun is moved. If greater film thickness is desired, apply additional $\frac{1}{2}$ or full box coat.
- (d) Allow to dry.

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The information and recommendations of TURCO concerning this product are based upon our laboratory tests and experience and to the best of our knowledge and belief are true and accurate. Since conditions of actual use are beyond our control, any recommendations or suggestions are made without warranty, express or implied.